

5/43

DART AEROSPACE LTD	Work Order:	24503
Description: Hinge Bracket	Part Number:	D2858-1
Drawing: D2858 Rev. B	Qty:	24

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	PF	05.10.12	24
2	METAL	Note: 1 Blank Makes 3 Parts Cut blanks 6.02" Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) M16954 Batch M18600	SP	05/10/21	24
3	HAAS	Machine per folio D2858-1	BG	05.10.22	24
4	QC	Inspect Level 2	BG	05.10.22	24
5	METAL	Tumble ^{100%} Deburr any rough edges after tumbling	BG	05.10.22	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	SAD	05/11/22	24
7	QC	Inspect Level 7	ML	05.11.21	24
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) per Dart QSI 005 4.3	FC	05.11.22	24
9	QC	Inspect Level 3	ML	05.11.22	24
10	STORES	Identify and stock	Loc 383	05/11/23	24
11	EXPEDITING	Close W/O Cost / Part: 545.05/11/24 24	PF	05/11/24	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.07.12	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

EC JUN 26 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 05/11/24

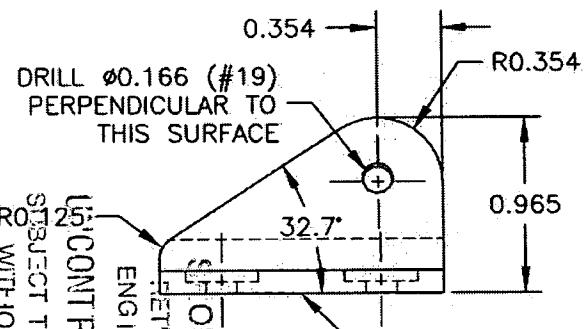
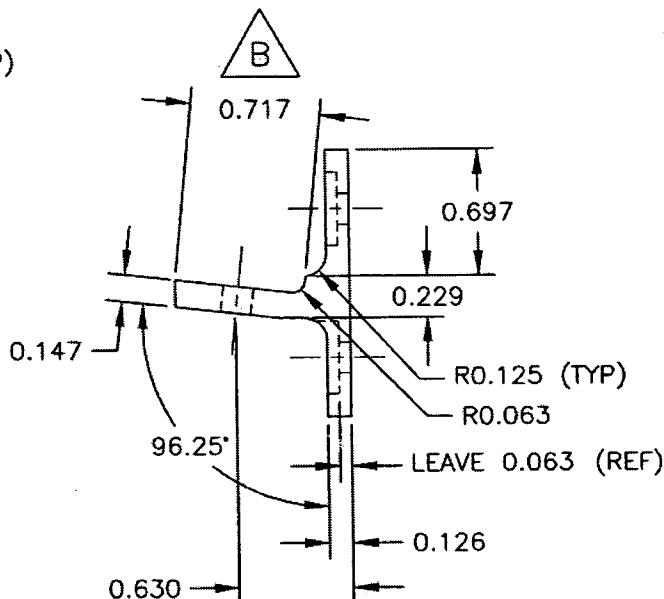
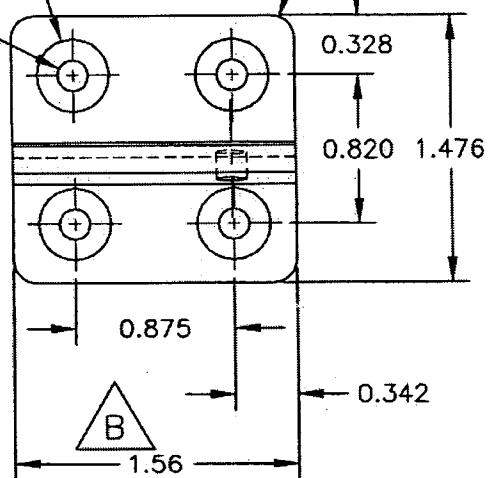
NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

$\phi 0.400$ C'BORE TO
LEAVE 0.063
(TYP 4 PLACES)

$\phi 0.171$
(TYP 4 PLACES)



ENgrave P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

© DART 1998

RELEASED
99.02.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
LE	KE	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
99.02.28	98.12.14	D2858
B	99.02.28	99.02.28
TITLE	REV. B	SHEET 1 OF 1
HINGE BRACKET		
SCALE		
1:1		

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
07:41 am

Work Order No : 0024503
 Project Name : D2858-1
 Project For : WK543
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2858-1
 Description : Hinge Bracket
 Manufactured : Yes
 Amount Req'd : 24
 Amount Done : 0
 Start Date : 10-08-05
 Est Finish Date : 10-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24503
Description: HINGE BRACKET		Part Number: D2858-1
Inspection Dwg: D2858	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.400 Colbow	±.010	.398	✓			
.063 thick	±.006	.067	✓			
Ø.171	+.0005 -.001	.171	—			
.125	±.010	.125	—			
.328	±.010	.328	—			
.820	±.010	.817	—			
1.4176	±.010	1.418	✓	—		
1.56	±.03	1.576	✓			
.875	±.010	.872	✓			
Ø.166	+.0005 -.001	.167	—			
.254	±.010	.254	—			
.354	±.010	.354	—			
.965	±.010	.972	✓			
PL.125	±.010	.125	✓			
96.25°	± 1/2°	96.25	—			
32.7°	± 1/2°	32.7	✓			
.147	±.010	.138	—			
.717	±.010	.720	✓			
.697	±.010	.697	✓			
.229	±.010	.232	✓			
.126	±.010	.122	✓			
.630	±.010	.636	✓			
.342	±.010	.342	—			

Measured by: <u>SG</u>	Audited by: <u>J.G.</u>	Prototype Approval: <u>N/A</u>
Date: 09-10-22	Date: 05/10/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	